

Date: Monday, 3/13/2006 7:29:46 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING BRACKET		
Job Number	: 26204					
Estimate Number	: 10604					
P.O. Number	: N/A			Part Number	: D2581	
This Issue	: 3/13/2006		S.O. No.	: N/A		
Prsh Rev.	: NC			Drawing Number	: D2581 REV A1	
First Issue	: N/A		Type	: PURCHASED PARTS		
Previous Run	: 25834			Project Number	: N/A	
Written By	: See Comment Below			Drawing Revision	: A1	
Checked & Approved By	: HJ 06.03.13			Material	: N/A	
Comment	: Est. D 01.07.17 Added info to step 2 SM			Due Date	: 3/30/2006	
					Qty:	104 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: 882 Laser cut as per Dwg D2581 Material: 304/316 SS 0.125" thick Material release note required	
2.0	D2581F	Mounting Bracket	
		Comment: Qty.: 1.0000 U(s)/Unit Total : 104.0000 U(s) Mounting Bracket	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes DQA: Date: 06/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/11	8	2 pieces were out of Tolerance	IB CHFV	Scrap destroy	SB 06/04/10	IB 06/04/10	IB 06/04/11	IB 06/04/11

NOTE: Date & initial all entries

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Drawing Name: MOUNTING BRACKET

Job Number: 26204

Part Number: D2581

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2581 using CNC Brake

SP

06/04/10

104

7.0

QC5

INSPECT WORK TO CURRENT STEP



Jac 04.10

104

Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Jac 04.10 104

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/S

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/04/11

104

Job Completion



u 06-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

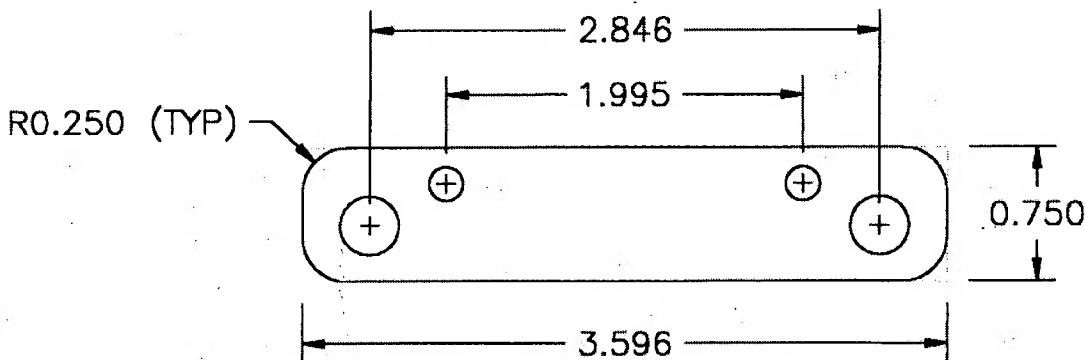
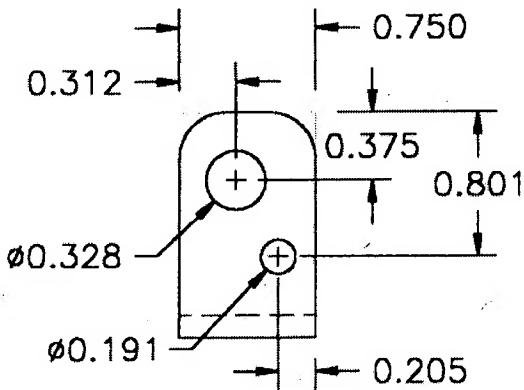
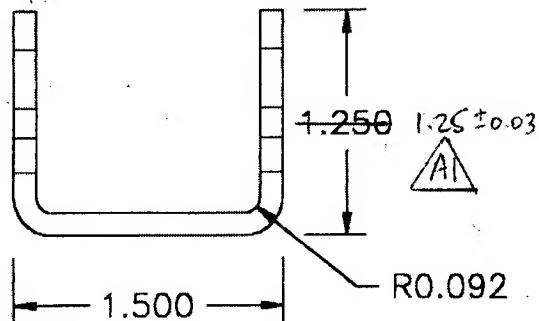
NOTE: Date & initial all entries

DART

DESIGN MIKE M	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bu</i>	APPROVED <i>M M</i>	DRAWING NO. D2581	REV. A SHEET 1 OF 1
DATE 96.06.27		TITLE MOUNTING BRACKET	SCALE 1:1
A1	<i>HP 04.05.14</i>	CHANGE TOLERANCE ON 1.25 DIMENSION	

RELEASED

96/07/23 BY



MATERIAL: 304/316 SS 0.125 THICK

SHOP COPY
RETURN TO
ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 26204

PS1020PC002-80802

OCT-20-2005 15:06

OLBERT METAL SALES

WILKINSON STEEL AND METALS LTD. PS1020PC002V

STAINLESS CR COIL 304
11 GA (114.119) X 48.0000"

PART NO.

905 795 1320 P.02

BL-WA-000504-001 20Oct05
Pg 1/1

Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I,
 Paragraph 4.3 by TÜV AUSTRIA GMBH (Notified Body Identification No. 0035)
 Inspection Certificate EN10204-3.1B

16.04.07

Shanxi Teigang Stainless Steel CO.,LTD Member
of Taiyuan Iron and Steel (Group) Co.,LTD
 NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China
 TEL: (0351)3013328 FAX: (0351)3017816
<http://www.tisco.com.cn>
 E-mail: tgbxg@tisco.com.cn

MILL TEST CERTIFICATE

MATERIAL	AISI304 No.2B Finish
SPECIFICATION	ASTM A240/A480 ASME SA240/SA180
L/C NO.	
CERTIFICATE NO.	20050636
DATE OF ISSUE	/ /

CUSTOMER
OLBERTCONTRACT NO.
1149DATE OF
06/05/05/20

COIL	Product	Melting furnace	Inspected stamp	Mark of the Manufacturer	
				ENVOD	Shanxi Taiyuan Stainless Steel Co.,ltd
NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)
8	QBP1133	SA4-278-4ZB	1	20GA × 48 × C	8528
9	Y501898	SA4-419-4ZY	1	14GA × 43 × C	5396
10	4501977	SA4-348-12B	1	11GA × 48 × C	5182
11	4501969	SA4-416-6ZY	1	14GA × 48 × C	7709
12	4501968	SA4-415-4ZY	1	14GA × 43 × C	7495
13	4501965	SA4-367-12B	1	11GA × 43 × C	3127
14	4500491	SA5-18-4ZJ	1	20GA × 48 × C	7668

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
QBP1133	0.049	0.470	1.090	0.023	0.003	18.140	8.050				0.039
Y501898	0.056	0.430	1.090	0.029	0.004	18.420	8.070				0.066
4501977	0.070	0.470	1.310	0.019	0.002	18.050	8.100				0.050
4501969	0.030	0.430	1.270	0.018	0.002	18.020	8.010				0.050
4501968	0.060	0.460	1.290	0.018	0.003	18.120	8.100				0.050
4501965	0.050	0.440	1.320	0.019	0.002	18.140	8.090				0.050
4500491	0.050	0.500	1.340	0.020	0.002	18.040	8.000				0.050

Mechanical Properties

Tem No.	Tensile R.m N/mm ²	R _m Yield _{0.2%} N/mm ²	R _m Yield _{0.2%} N/mm ²	Elongation %	Corrosion Tests	Hardness		
						HRB	HV	HRG
QBP1133-T	670	290		55			178	
Y501898-T	669	289		60		83		
4501977-T	615	279		60		86		
4501969-T	653	298		61		84		
4501968-T	650	294		58		84		
4501965-T	690	283		60		85		
4500491-T	660	329		60			172	

Surface and dimensions controlled: O.K.

Work inspection: 3-S

Page 2 of 3



PO 800

New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waikato
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5337/23917

CUSTOMER	Weldco	P50505D1002												SPECIFICATION ASTMA1068 CS Type A						CERTIFICATE No TC115838				
CUSTOMER D/N	90-2JN-742													PRODUCT CRA WIDE COIL						PAGE 1 of 1				
MILL D/N	486968													DIMENSIONS 8.033" x 48" x Coil						DATE 02 August 2005				
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT												MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)										
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE(%)	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS HRB	r (%)	LENGTH (feet)
x100												x1000	x10000	x100										
R9-464817-00	844863	6	TR	20	7	17	15	23	14	2	3	1	3	Good					45			2618		
R9-464818-00	844863	6	TR	20	7	17	15	23	14	2	3	1	3	Good					45			2664		
R9-464819-00	779675	6	TR	20	14	16	11	21	13	2	3	1	3	Good					49			2618		
R9-464820-00	779675	6	TR	20	14	16	11	21	13	2	3	1	3	Good					49			2825		
R9-464821-00	779674	6	TR	21	13	17	13	22	17	2	3	1	3	Good					50			1923		
R9-464822-00	779674	6	TR	21	13	17	13	23	17	2	3	1	3	Good					50			1978		

YIELD STRESS (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=20mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=0 (B)=0.0 (C)=0.05 (D)=(0+80+2x45)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15	(C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST